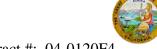
## DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-008697 Address: 333 Burma Road **Date Inspected:** 10-Aug-2009

City: Oakland, CA 94607

**OSM Arrival Time:** 645 **Project Name:** SAS Superstructure **OSM Departure Time:** 1845 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes Li Zhi jiang/ Zhang Yaxu No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG** Components

## **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During random visual inspection of CB-012, Caltrans Quality Assurance (QA) Inspector discovered a total of (2) Two, full length (45mm and 30mm) linear indications in Tack Welds. The member is identified as OBG Cross Beam. The weld designations reviewed are as FB204-033-065 and FB204-035-066. Caltrans Quality Assurance (QA) Inspector also evaluates those linear indications by Magnetic Particle testing. This QA inspector generated a TL 015 incident report on this date.

During random visual inspection of CB-012, Caltrans Quality Assurance (QA) Inspector discovered a excessive root opening on weld joint FB204-033-063. According to approved WPS-B-T-2231-B-U2-F, root opening is 0~3mm (+2, -0mm). The recorded root opening is 9~10 mm. This QA inspector generated a TL 015 incident report on this date.

### Bay #2

This QA inspector observed that all the required NDT work is completed on Longitudinal Diaphragms and item ready for green tag. This QA Inspector issued green tags for Longitudinal Diaphragms on this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

- -(FB011-028) Green Tag- 009953.
- -(FB011-030) Green Tag- 009954.
- -(FB011-033) Green Tag- 009956.

# WELDING INSPECTION REPORT

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Bay #3

This QA inspector observed that all the required NDT work is completed on Longitudinal Diaphragms and item ready for green tag. This QA Inspector issued green tags for Longitudinal Diaphragms on this date. The member is identified as OBG Components. The weld designations reviewed are as follows: -(FB019-009) Green Tag- 009970.

This QA inspector observed the following work in progress: Bay#3

SAW welding of weld joint CB202C-014-004 located on CB202-014. Welder is identified as 062406 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint CB202F-014-001/002 located on CB202-014. Welder is identified as 062406 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint fit-up verified by SMAW welding process of weld joint CB202B-014-001 located on CB202-014. Welder is identified as 058102 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS

#### Bay#2

Joint fit-up verified by SMAW welding process of weld joint FB3059-003, 005, 022, 023, 024 located on FB3059-003. Welder is identified as 205098 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS

Bay#8

SAW welding of weld joint CB202C-013-003/004 located on CB202-013. Welder is identified as 207463 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

#### **Summary of Conversations:**

No relevant conversations.

## **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

# WELDING INSPECTION REPORT

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Inspected By:	Patel, Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer